

Work Order ID 121865

Wednesday, July 02, 2014 3:37:34 PM

121865

Page 1

Item ID: D2569 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge
 Start Date: 7/02/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/02/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 140704 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2569	Rev B

100 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

100

Powdercoat
Powder Coating

Memo

Note: Advise that hinges are to be broken back and forth immediately after to ensure free mobility of hinge.

11/08/13 10:00
 START TIME:
 OVEN TEMPERATURE: 400°
 FINISH TIME: 12:20

2 @ 14 9-23. **DAS 34 9-89**

110 QC3- Inspect Part Finish 0.00

110

QC
Quality Control

Memo

2 @ 14/09/23.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location <u>CA</u>	0.00							DAS
120									26
Packaging	Memo	0.00				2x	SEP 24 2014		9-89
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLD 140924
MF 14-9-24

DQA: _____ Date: _____



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Picklist Print

Wednesday, July 02, 2014 3:37:34 PM

Page 1

Work Order ID: 121865

121865

Parent Item: D2569

D2569

Parent Item Name: Hinge

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D01.12.17Changed processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20257-3-7200

Purchased

No

100

f

61.6420

6

60

MS20257-3-7200

14-9-15

PIANO HINGE

DAS
34
9-89

Location

Loc Qty

Loc Code

ST209a

61.642

m127172

12.6

m127393

9.442

m128401

4

m128813

2.6

m128923

33

11130358.

12

DQA: _____ Date: _____



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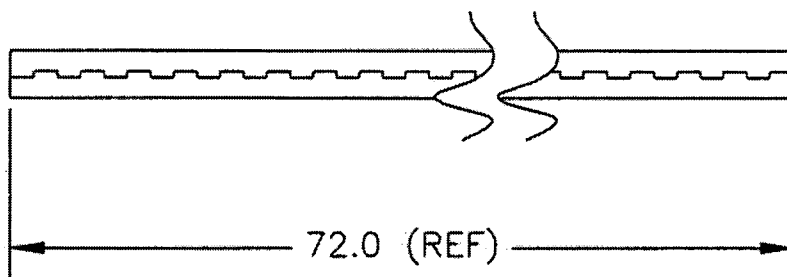
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DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DA</i>	DRAWING NO. D2569	REV. 8 SHEET 1 OF 1
DATE 99.01.05		TITLE HINGE	SCALE 1:4
A	96.06.24	NEW ISSUE	
B	99.01.05	ADDED MS20257-3-7200 AND P/C REMOVED HOLE PATTERN	

RELEASED
99.01.21 *KE*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121865 *u/c*

1407-04

NOTES:

- 1) MAKE FROM MS20257-3-7200
- 2) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ENSURE HINGE MOVEMENT IS MAINTAINED IMMEDIATELY AFTER POWDER COAT
- 4) USE 0.040 LOCKWIRE TO SECURE HINGE PIN AT BOTH ENDS (USE #60 DRILL FOR LOCKWIRE HOLE)